

Date: Friday, 01/08/2008 10:43:15 AM
 User: Julie Lecocq

Process Sheet

ASAF

| | | | | | | |
|-----------------------|---|--|--------------|------------------|---------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BRACKET | | |
| Job Number | : 40907 | | | Part Number | : D33045 | |
| Estimate Number | : 10901 | | | Drawing Number | : D3304 REV B | |
| P.O. Number | : | | | Project Number | : N/A | |
| This Issue | : 01/08/2008 | | S.O. No. : | Drawing Revision | : B | |
| Prsht Rev. | : NC | | | Material | : | |
| First Issue | : / / | | Type : | PURCHASED PARTS | Due Date | : 15/08/2008 Qty: 20 Um: Each |
| Previous Run | : 40203 | | | | | |
| Written By | : | | | | | |
| Checked & Approved By | : JUL 08.05 | | | | | |
| Comment | : Est A 04.09.07 New issue KJ/JLM Est Rev B now water jet 07-11-01 DD verified: EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | M304S20GA | 304/316 .040 Sheet | |
| | | Comment: Qty.: 0.0605 sf(s)/Unit Total : 1.2100 sf(s) 304/316 .040 Sheet | |
| | | Batch: 109088 HB 8-9-4 | |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3304 | |
| | | Dwg Rev: B HB 8-9-4 Prog Rev: B | |
| | | 2-Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | HB 8-9-4 | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | |
| 5.0 | BRAKE NC | NC BRAKE | |
| | | Comment: NC BRAKE 1-Deburr if necessary 2-Form as per Dwg D3304 | |
| | | SB 08/10/23 (22) | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40907

Part Number: D33045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



located

S.08/10/23 (x22)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

L08/23 (22)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/24 (10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

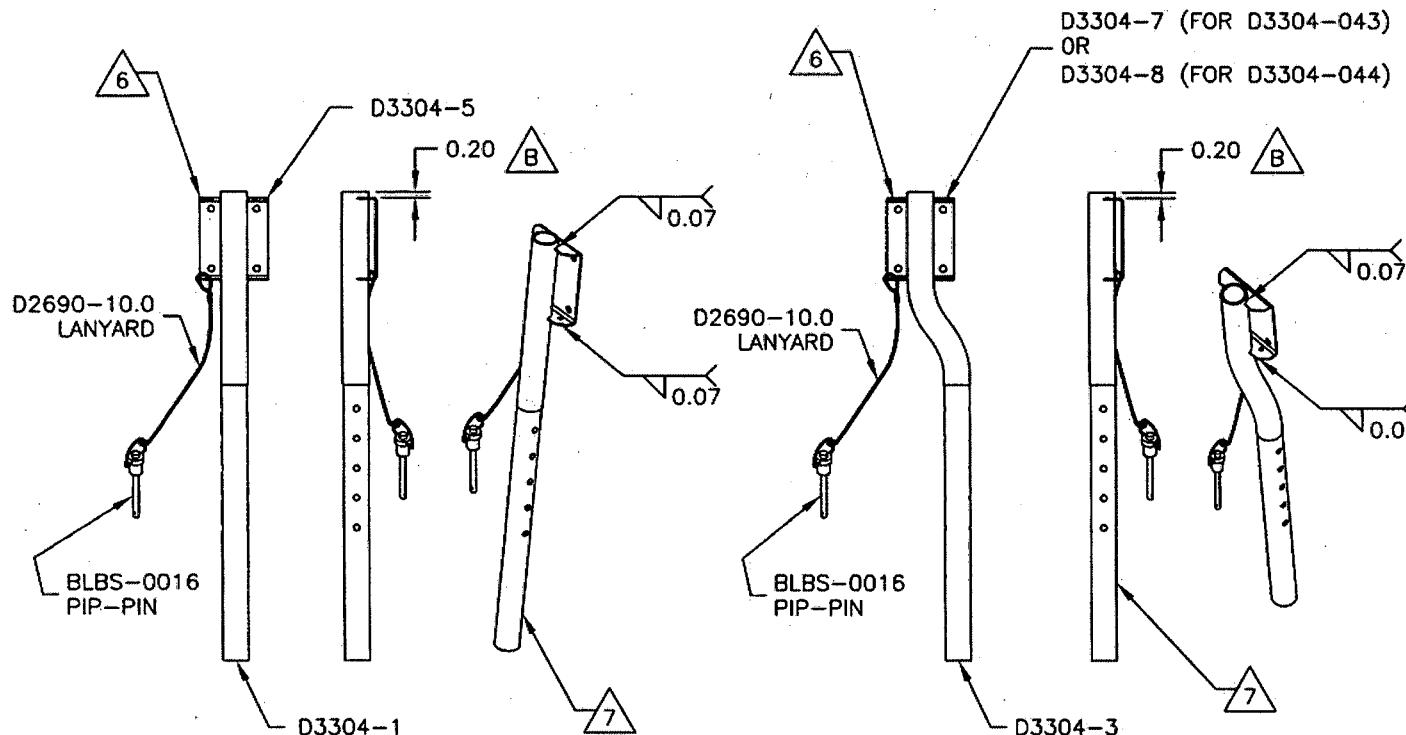
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|---------------------|-----------------------------------|---|
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D3304 |
| DATE 05.07.15 | TITLE TUBE ASSEMBLY | SHEET 1 OF 4 |
| A 04.08.18 | NEW ISSUE | |
| B 05.07.15 | UPDATE DIMENSIONS; ADD D3304-7/-8 | SCALE 1:6 |

RELEASED
25-08-11
H**D3304-041 TUBE ASSEMBLY****D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE****D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11" BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

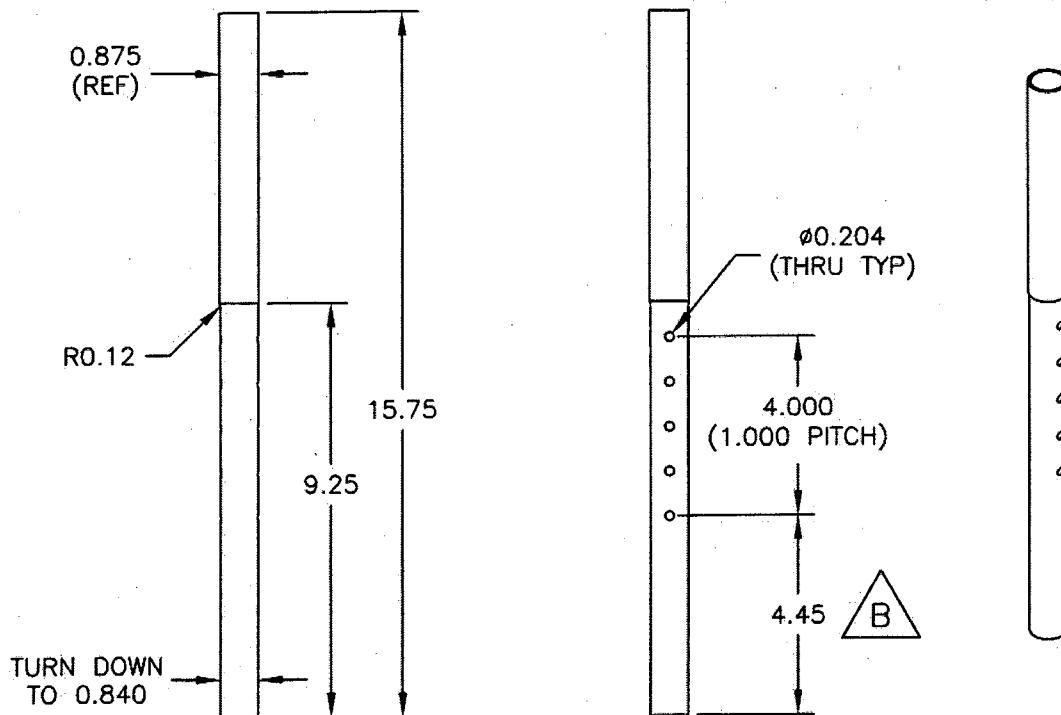
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WITHOUT NOTICE
WORK ORDER
NO. 14246

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| CHECKED <i>MM</i> | APPROVED <i>MM</i> | DRAWING NO. D3304 |
| DATE 05.07.15 | TITLE TUBE ASSEMBLY | REV. B SHEET 2 OF 4 SCALE 1:4 |

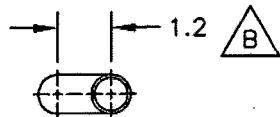
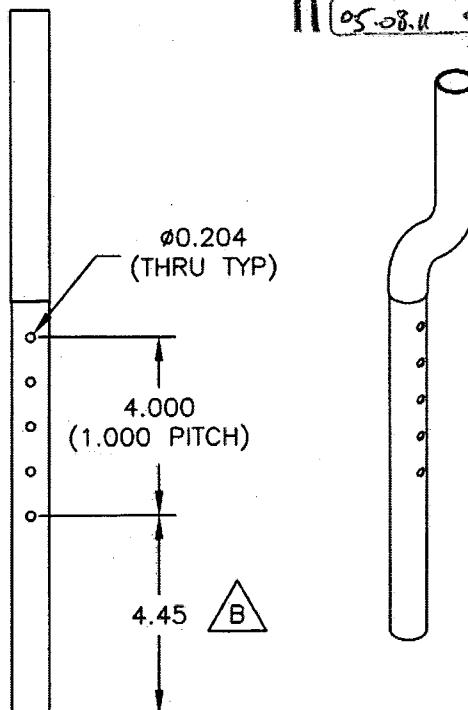
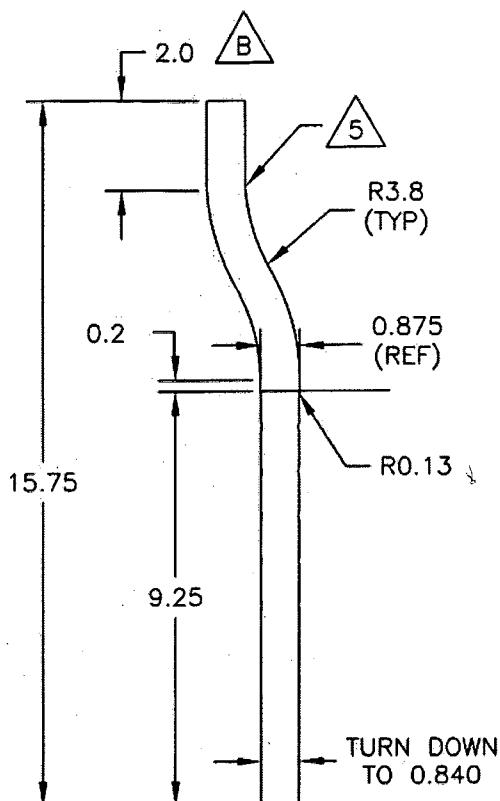
RELEASED
05.08.11 *MM***D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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| | | | |
|-------------------------------|--------------------------------|---|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3304 | REV. B SHEET 3 OF 4 |
| DATE 05.07.15 | TITLE TUBE ASSEMBLY | | SCALE 1:4 |

**D3304-3 TUBE****D3304-3 NOTES:**

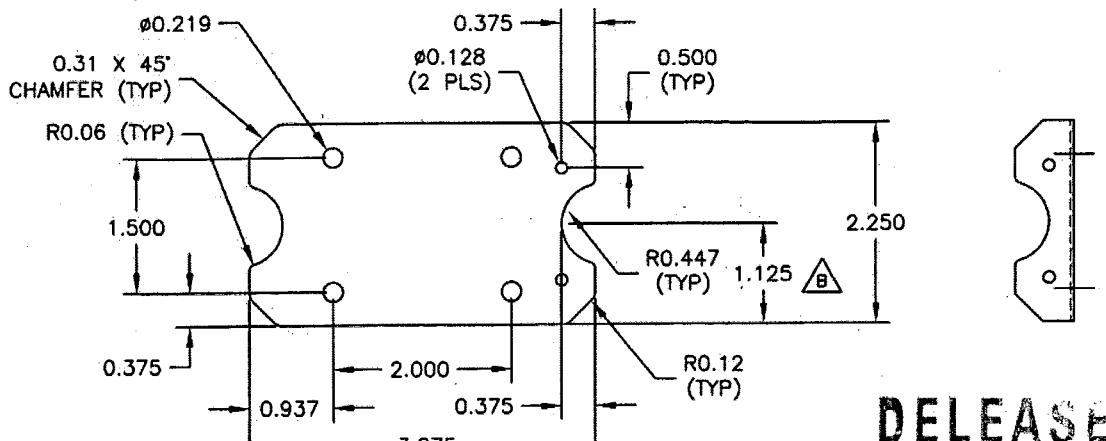
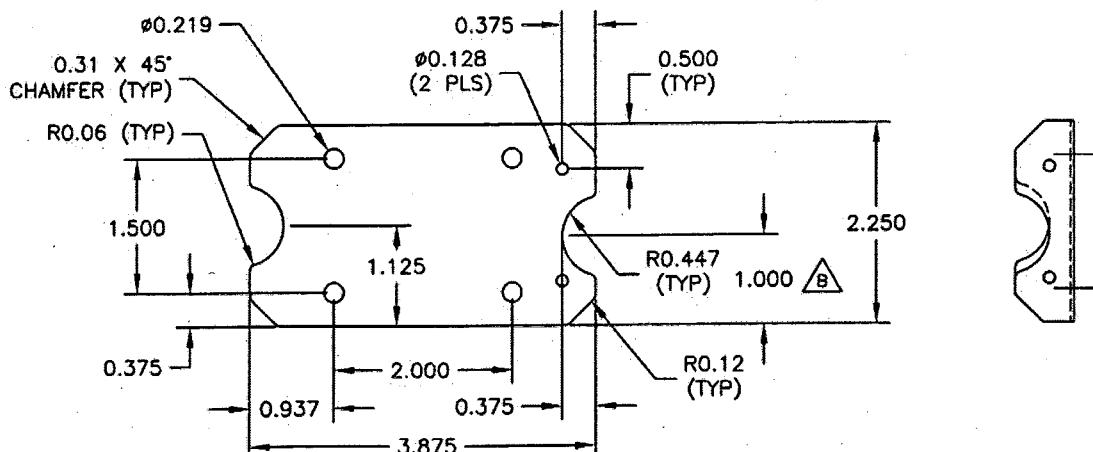
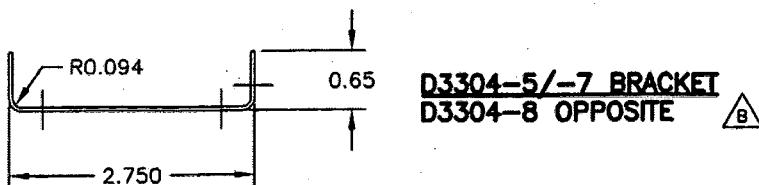
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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NO. 40907

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| | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3304 | REV. B SHEET 4 OF 4 |
| DATE 05.07.15 | | TITLE TUBE ASSEMBLY | SCALE 1:2 |

**D3304-5 FLAT PATTERN****D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

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WITHOUT NOTICE
WORK ORDER
NO. U15901

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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| | | |
|---------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 4D907 |
| Description: BRACKET | Part Number: | D3304-5 |
| Inspection Dwg: D3304-5, Rev: K | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

| | | |
|---------------------|--------------------|----------------------------|
| Measured by: | Audited by: | Prototype Approval: |
| Date: 8-9-4 | Date: 08/02 | Date: 4 |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|-----------------|
| A | | New Issue | KJ/JLM | |